

8. Install the right-hand crankcase cover as described in Chapter Four.

9. Refill the engine with the correct type and quantity oil as described in Chapter Three.

10. Start the engine and check for oil leaks.

11. Adjust the clutch as described in Chapter Three.

MANUAL CLUTCH

Removal/Disassembly

Refer to **Figure 13** for this procedure. The centrifugal clutch has to be removed prior to removing the manual clutch.

1. Remove the centrifugal clutch assembly as described in this chapter.

2. Using a criss-cross pattern, loosen the clutch bolts (A, **Figure 14**) securing the clutch lifter plate.

3. Remove the clutch bolts, the lifter plate and bearing and the clutch springs (B, **Figure 14**).

4. Use a chisel and hammer and carefully unstake the locknut.

5. Use an impact driver and loosen the clutch locknut (**Figure 15**).

6. Remove the locknut and lockwasher (A, **Figure 16**).

7. Remove the clutch center, plates, discs, pressure plate, clutch outer housing and outer guide (B, **Figure 16**) from the transmission shaft as an assembly.

8. Inspect the clutch parts as described under *Manual Clutch Inspection* in this chapter.

Assembly/Installation

NOTE

If new friction discs and clutch plates are being installed, apply new engine oil to all surfaces to avoid having the clutch lock up when used for the first time.

1. Working at your workbench, install a friction disc (**Figure 17**) and then a clutch plate (**Figure 18**) onto the clutch center. Continue to install a friction disc, then a clutch plate, and alternate them until all are installed. The last item installed is a friction disc (**Figure 19**).

2. Install the pressure plate (**Figure 20**).

3. Install the outer guide (A, **Figure 21**) into the backside of the clutch outer housing (B, **Figure 21**).

4. Turn the clutch outer housing over and install the thrust washer (**Figure 22**).

5. Slide on the clutch parts (clutch center, friction discs, clutch plates and pressure plate) assembled in Step 1 into the clutch outer housing (**Figure 23**). Push the assembly on slowly, carefully aligning the tabs of the friction discs into the slots in the clutch outer housing (**Figure 24**).

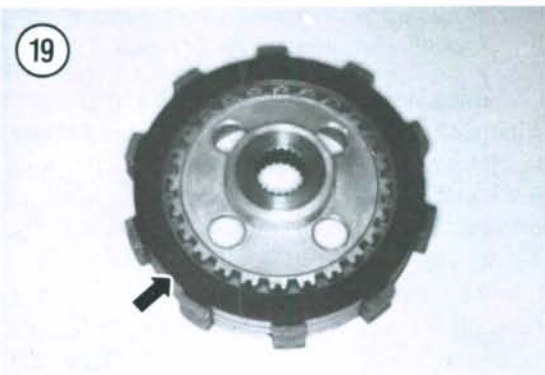
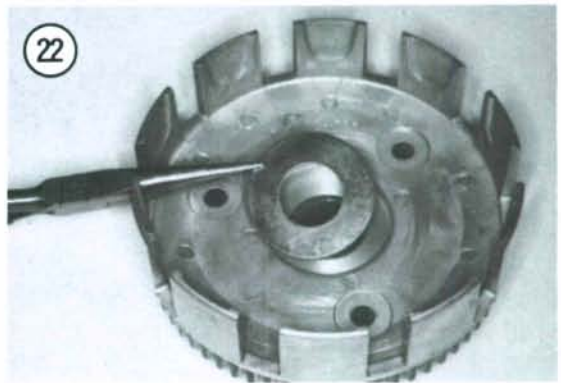
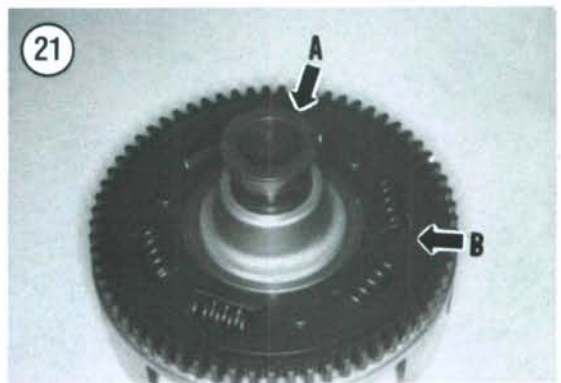
6. Install the assembled clutch assembly onto the transmission shaft (**B**, **Figure 16**).

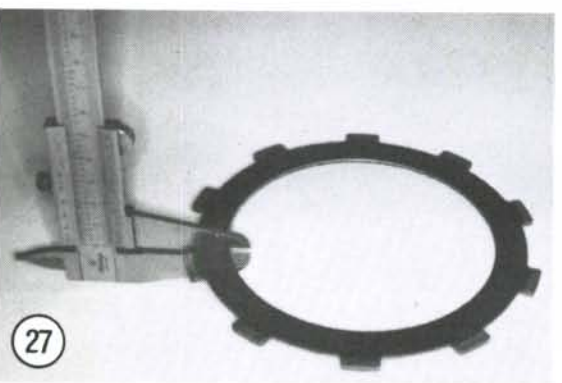
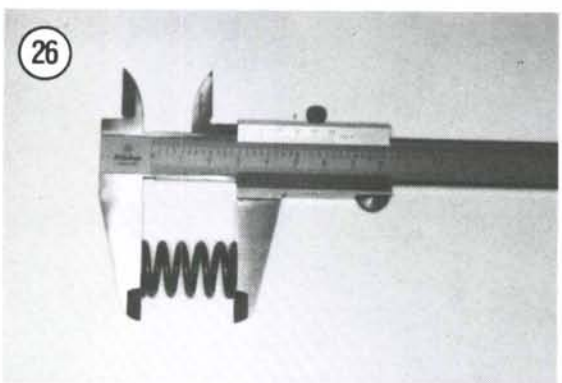
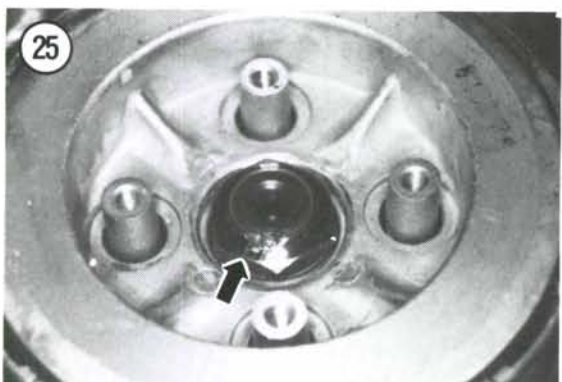
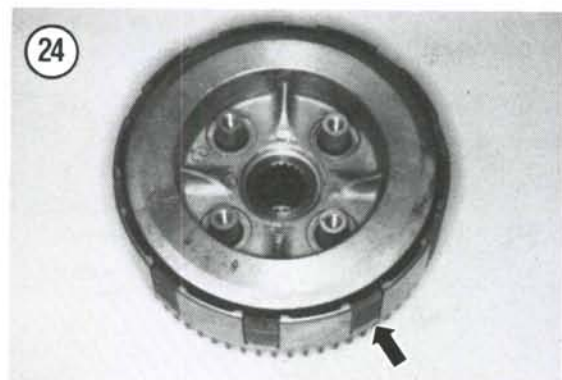
7. Install the lockwasher with the dished side facing toward the outside. The word "OUTSIDE" stamped on it must face outward (**A**, **Figure 16**).

8. Install the locknut (**Figure 15**) and tighten to the torque specification listed in **Table 2**.

9. Using a hammer and center punch or punch, stake the locknut (**Figure 25**) into the recess in the transmission shaft.

10. Install the clutch springs, the clutch lifter plate and bearing (**B**, **Figure 14**), then install the clutch bolts (**A**, **Figure 14**). Tighten the bolts securely in a criss cross pattern in 2 or 3 stages to the torque specification listed in **Table 2**.





11. Install the centrifugal clutch as described in this chapter.

12. Refill the engine with the recommended type and quantity oil as described in Chapter Three.

13. Adjust the clutch as described in Chapter Three.

MANUAL CLUTCH INSPECTION

1. Clean all parts in a petroleum-based solvent such as kerosene and thoroughly dry with compressed air.

2. Measure the free length of each clutch spring as shown in **Figure 26**. Refer to **Table 1**. If any of the springs are worn to the service limit or less, replace all springs as a set.

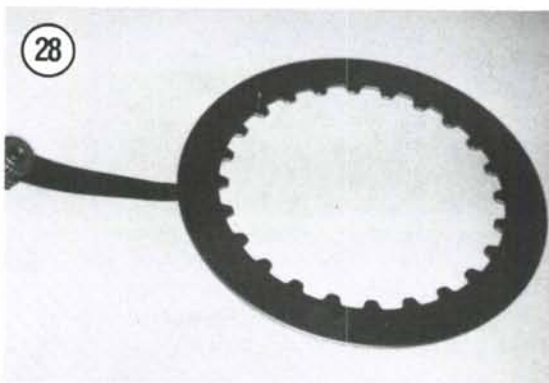
3. Measure the thickness of each friction disc at several places around the disc as shown in **Figure 27**. Refer to **Table 1**. Replace any disc that is worn to the service limit or less. For optimum performance, replace all discs as a set even if only a few need replacement.

4. Check the clutch plates for warpage with a flat feeler gauge and a surface plate such as a piece of plate glass (**Figure 28**). Refer to **Table 1**. Replace any that are warped to the service limit or more. For optimum performance, replace all plates as a set even if only a few need replacement.

5. Inspect the grooves and studs in the pressure plate (**Figure 29**). If either show signs of wear or galling the plate should be replaced.

6. Inspect the inner splines (**Figure 30**) and outer grooves (**Figure 31**) in the clutch center; if damaged, the clutch center should be replaced.

7. Inspect the gear teeth (**Figure 32**) on the clutch outer housing. Remove any small nicks on the gear teeth with an oilstone. If damage is severe, the clutch housing should be replaced.



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